

RELIABLE EQUIPMENT

**CRAFTED WITH PRIDE IN THE U.S.A.
USED WITH CONFIDENCE AROUND THE WORLD**

301 Ivyland Road - Warminster, PA 18974

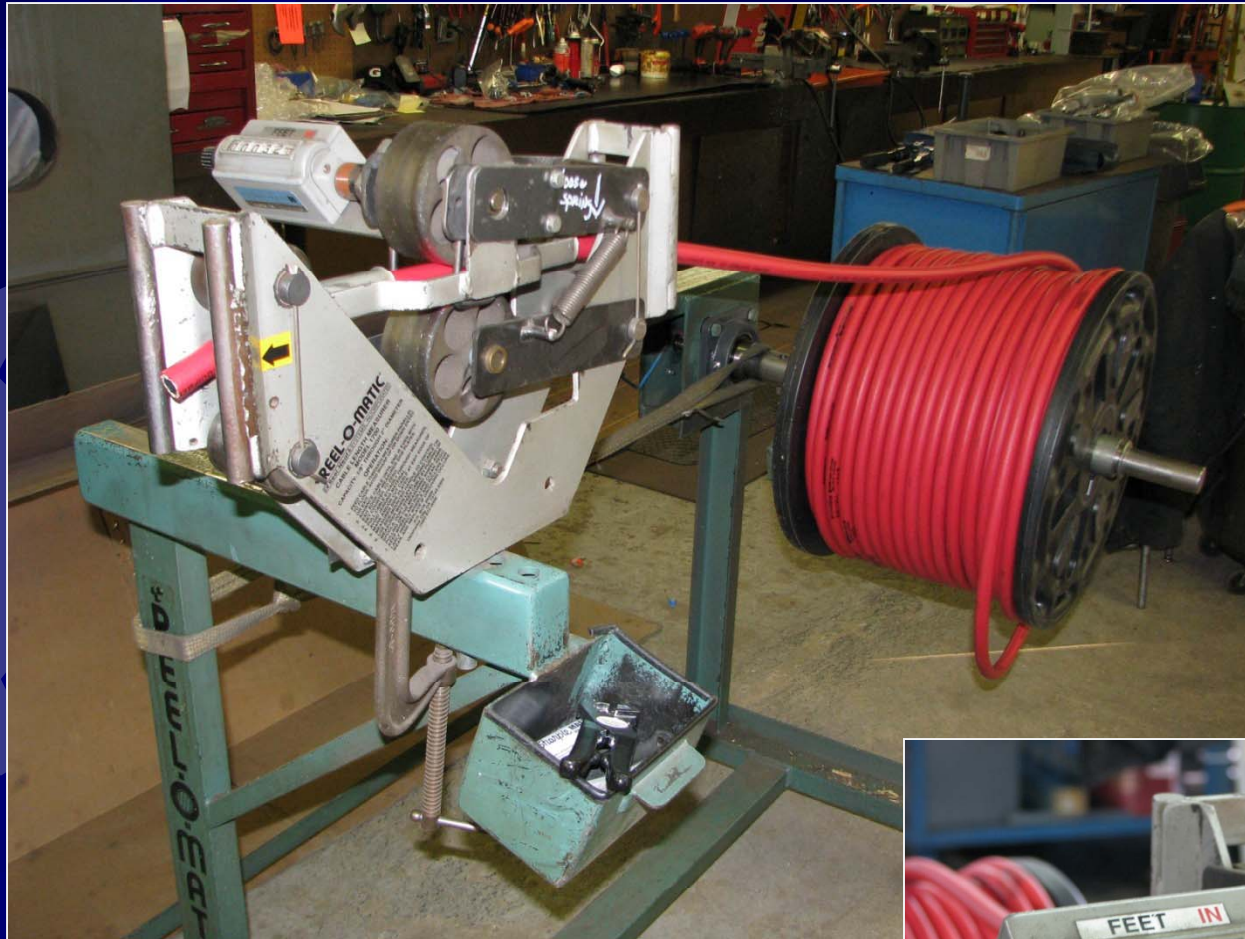
Phone: 215-357-3500 Toll Free: 800-966-3530

Fax: 215-357-9193



LOW PRESSURE HOSE ASSEMBLY

- The following instructions are to be fully understood before beginning hose assembly.
- Read and proceed at your own pace.
- Press the enter key to advance to next process.
- Consult your supervisor with any questions.
- This file is available for your review at any time.



Set up the Reel-O-Matic hose counter with the appropriate hose type.



Real Out Proper Hose Length.



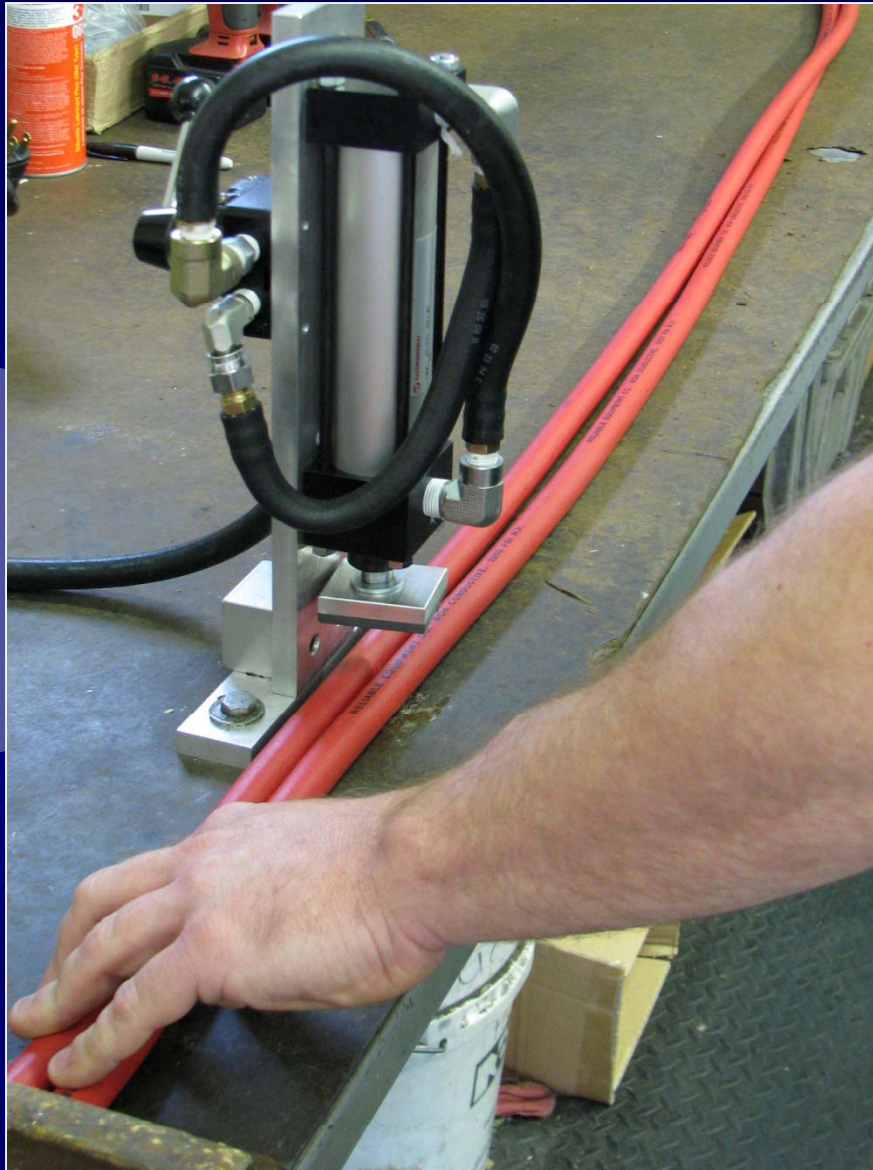
Cut to length.



Use approved hose cutter only.
Align cutter with guide as marked with arrow. (Right)



Soak strain relief tubing in clean hot water.
Relief tubes will be used later.



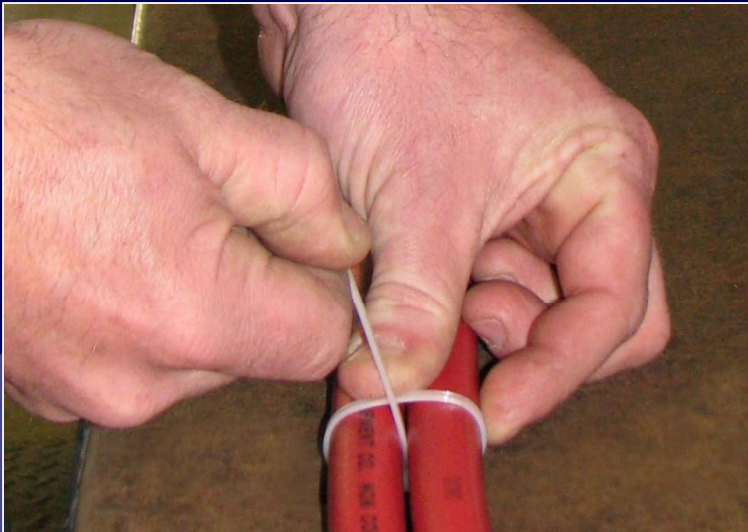
Lay cut hoses on clear work area.



Butt hose ends against STOP.



Secure with hose vise.



Wrap banding around & secure, pulling tail between and through hoses.



Cut banding tail below wrap.



Tighten hose banding.



Band will self center as shown.



Trim hoses to equal lengths



A clean straight cut is important.



Spray approved lubricant onto hose end.



Remove tubing from water.



Spray approved lubricant into strain relief.



Install strain relief tubing onto hose.



Slide relief past hose end.



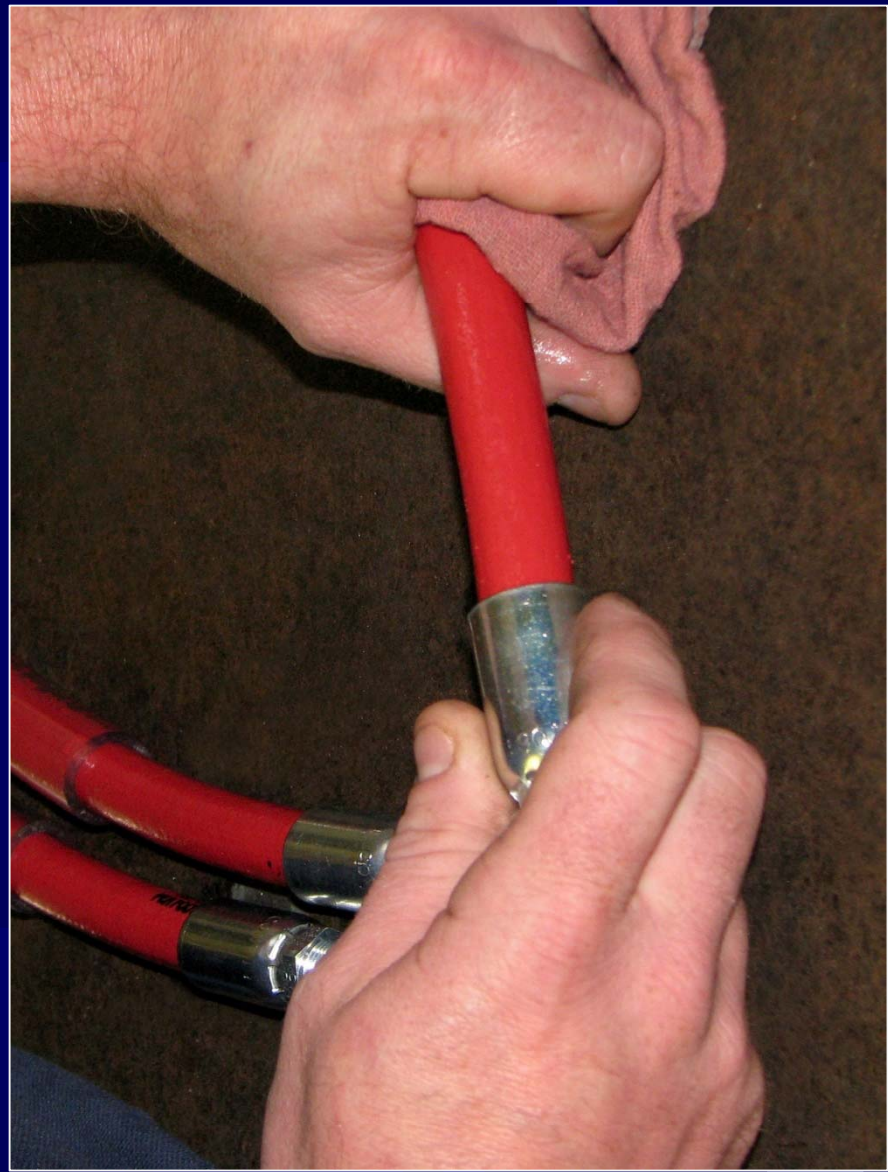
Allow room for end fitting.



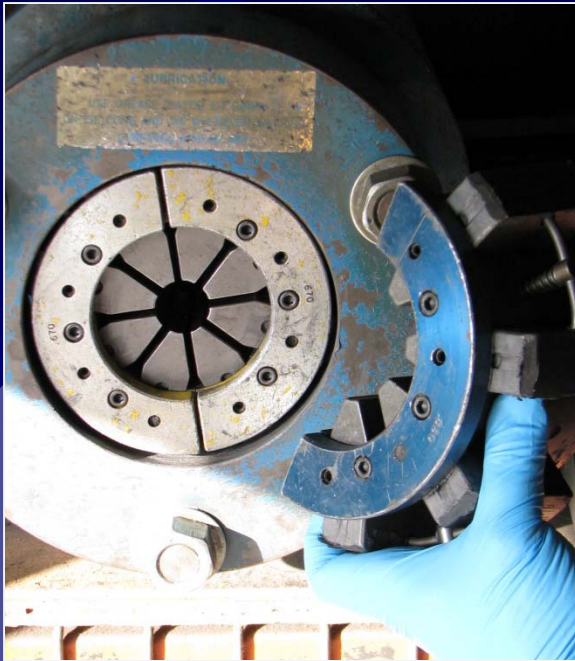
Visually inspect fitting.



Install fitting onto hose end.



Insert hose end to bottom of fitting seat.



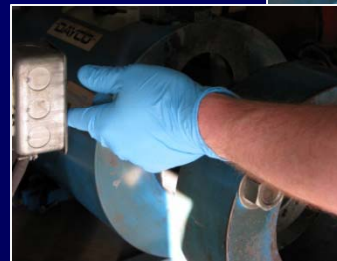
Chose proper die for hose type.



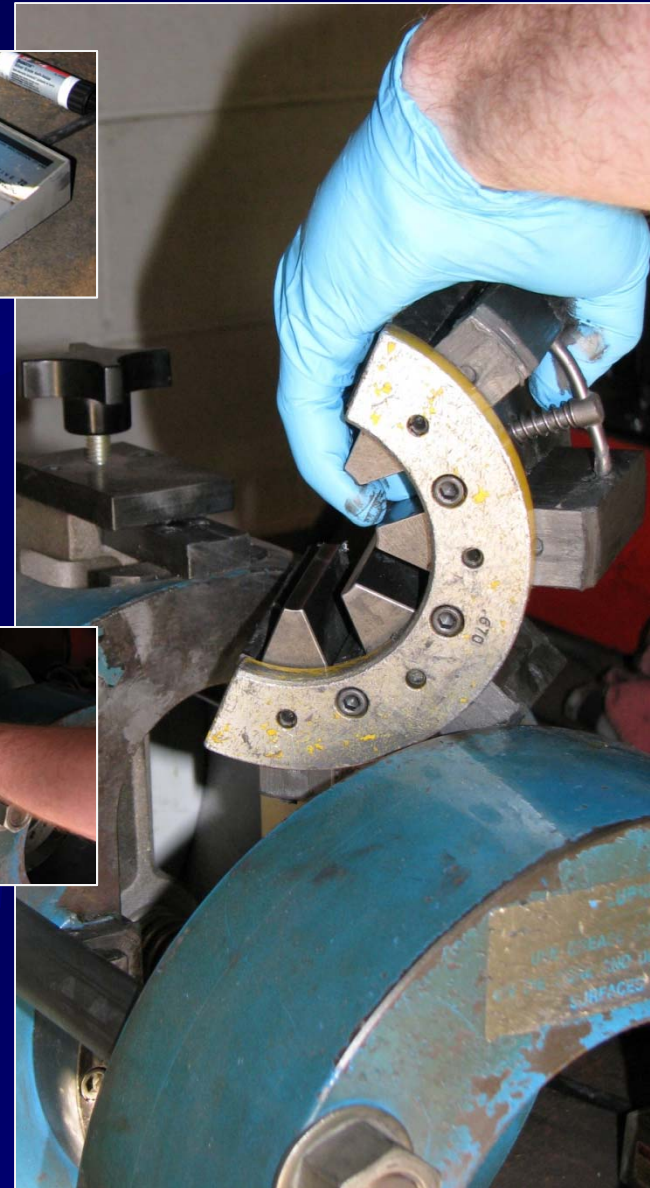
Turn on machine to open.



Toggle
OPEN.



Turn OFF
Power



Insert appropriate die into seat.



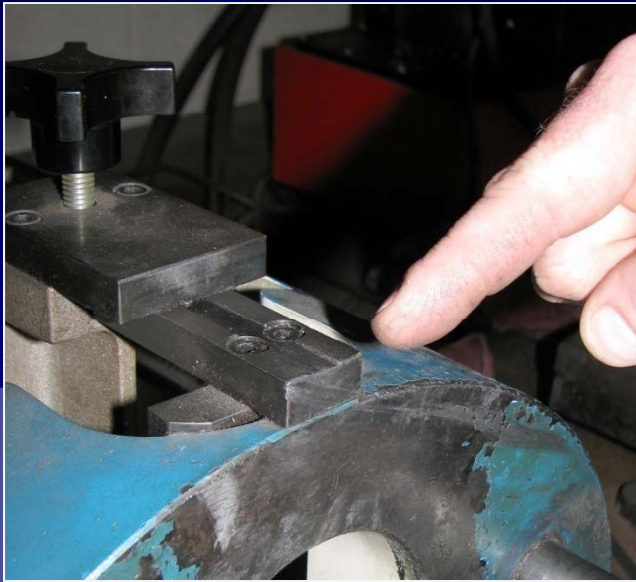
Lubricate
with Loctite
Silver Grade
Anti Seize
Quickstick



Thoroughly apply to die guide.



Lubricate Inner compression works.



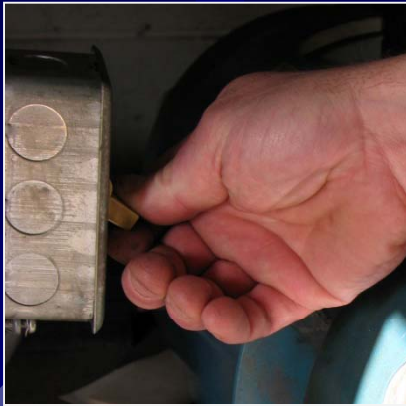
Set depth guide.



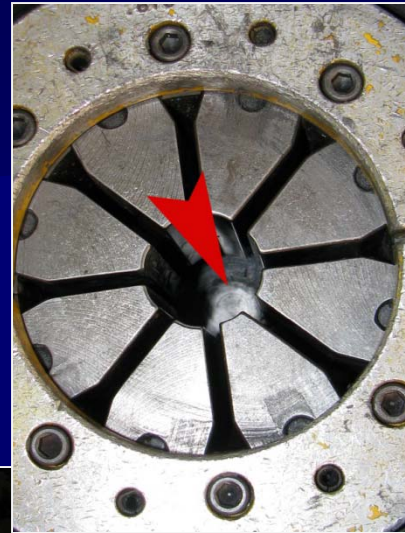
Visually check depth to fitting.



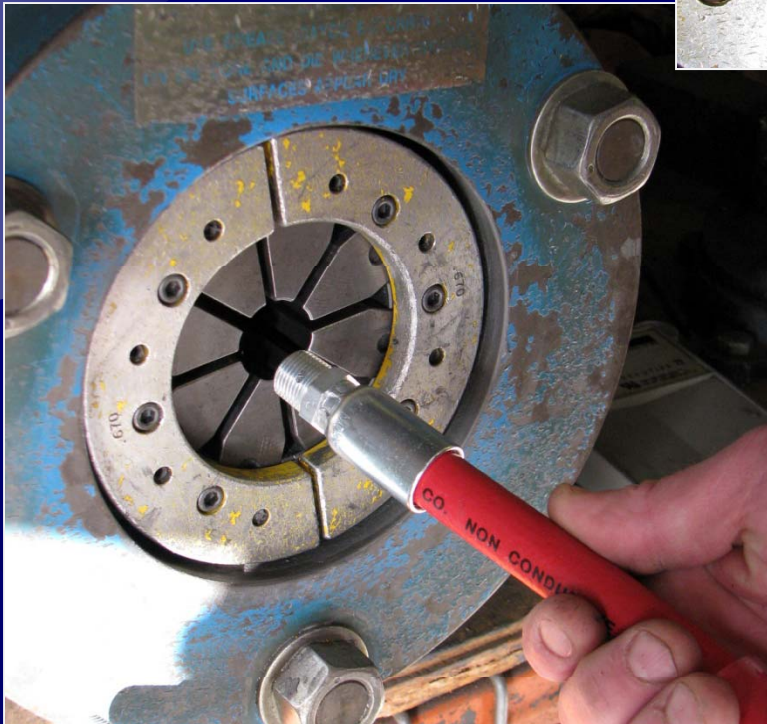
Set compression amount. (76)



Turn on
Power .



Insert assembly
until flush with
rear plate.



Insert hose and fitting into die jaws.

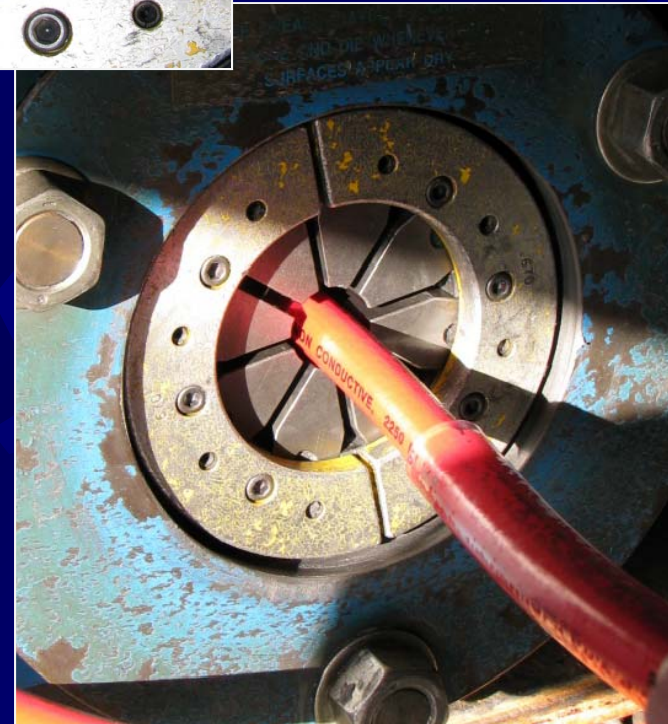


Plate controls compression depth.



Toggle to make compression.



Toggle to open.

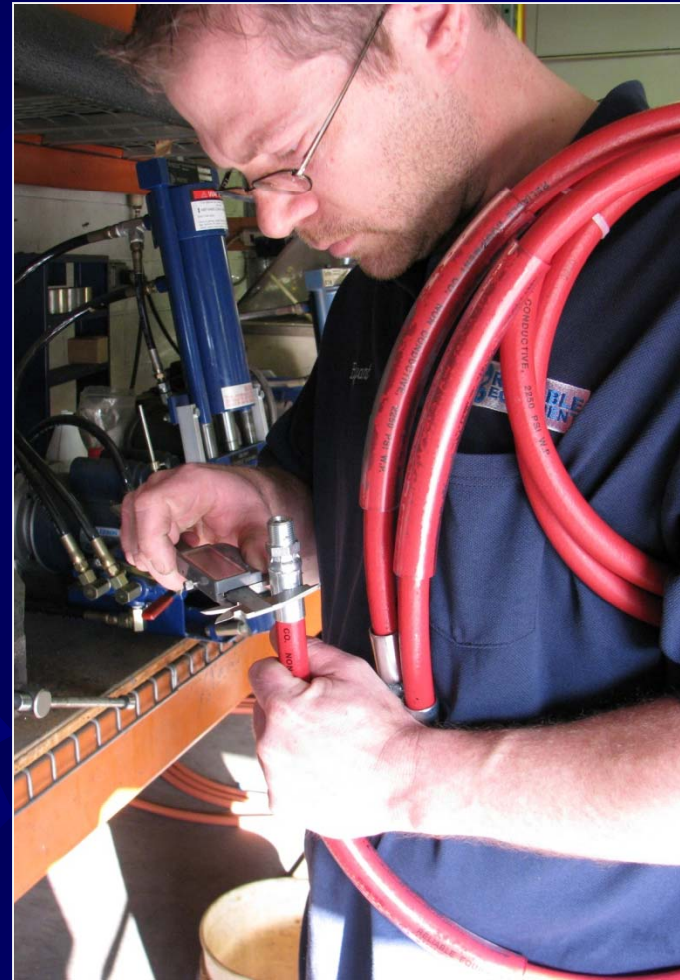


Remove fitting & visually Inspect for quality.

Check Compression for First Crimp & Batch Inspect Every 25th Piece.



Use a caliper to inspect for proper compression of the end fitting.



Gauge several areas to ensure a uniform crimp.

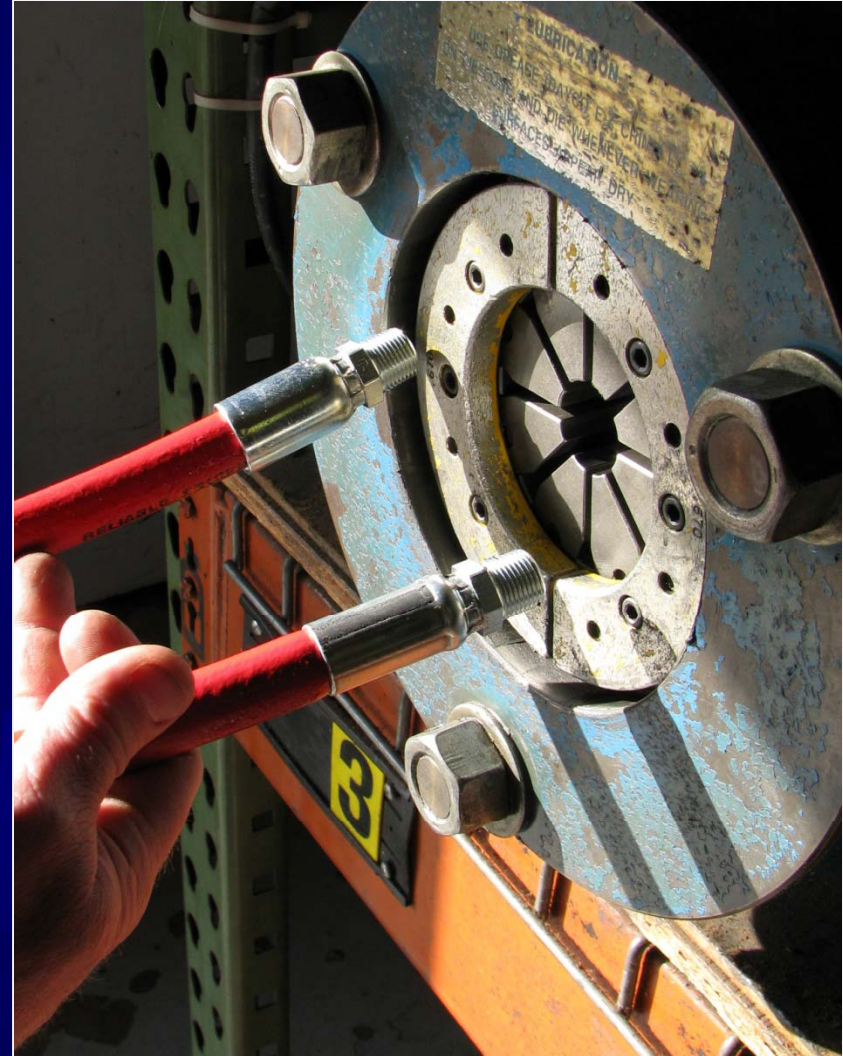
Repeat entire process as required.



Toggle to make compression.



Toggle to open.



Remove fitting & visually Inspect for quality.

A relief guide has been set up using smoothed wrench & bench vise.



Insert the hose assembly into relief guide below the relief tubing.



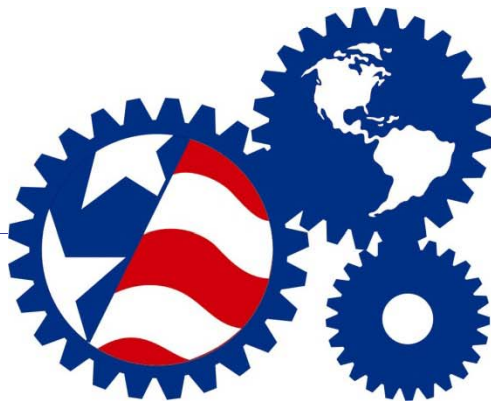
Pull the hose back while guiding the relief forward



Move the strain relief forward to the base of the fixed nut on the fitting.



Inspect strain relief placement. Assembly is complete.



RELIABLE EQUIPMENT

**CRAFTED WITH PRIDE IN THE U.S.A.
USED WITH CONFIDENCE AROUND THE WORLD**

301 Ivyland Road - Warminster, PA 18974

Phone: 215-357-3500 Toll Free: 800-966-3530

Fax: 215-357-9193